

Order ID 71277

June 24, 2011 3:45:10 PM

Ship July 6



Page 1

Item ID: D3324-041

Accept



Setup Start



Revision ID:

Item Name: Basket Base Assembly

Stop



Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 1406-27 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D3324	Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	m112786
4	D3324-3	Full Length Tube	m112786
2	D3324-5	Top End Tube	m112786
2	D3324-7	Bottom EndTube	m112786
10	D3324-9	Vertical Tube	m112786

1406-29

2- Weld as per dwg

AIR 4130 Rod : M1000TS

110

0.00



QC

Memo

0.00

Quality Control

Ex 11-07-04

1 0 BE 11/07/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

δ w/o 7/05

~~10 6/24/2011~~

121



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

~~1X δ m-11/07/05~~

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

M 117745

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

IX / m-11/07/05

1 0 8 11-7-5.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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**Work Order ID 71277**

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Page 4

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Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



Packaging

Packaging

Operation  
Description

Identify as per dwg &amp; Stock Location:

6-A

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

160



QC

Quality Control

Memo

W/O 7127C

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF

11-07-05

Dart Aerospace Ltd

W/O:

**WORK ORDER CHANGES**

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

## Picklist Print

Friday, June 24, 2011 3:45:17 PM

Page 1

**Work Order ID:** 71277



**Parent Item:** D3324-041



**Parent Item Name:** Basket Base Assembly

**Start Date:** 6/24/2011

**Required Date:** 6/30/2011

**Comments:** IPP Rev:A 05.02.09 New issue KJ/JLM  
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Start Date: 1/01

Received Oct. 1, 1900

Dart Aerospace Ltd

W/O:

**WORK ORDER CHANGES**

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Friday, June 24, 2011 3:45:17 PM

Page 2

Work Order ID: 71277



Parent Item: D3324-041



Parent Item Name: Basket Base Assembly

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased No

100 f 414.3443 46.6 49.05263



SAN

11-06-27

4130 Square tube .500 x .500 x .035w

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT034	414.3443	
109127	216	
109385	15.75	
112786	182.5943	

M569EX0.50-18F

Purchased No

100 sf 74.0000 28 28



49.0527

LPCR-07-04

569 Expanded Metal

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	74	
112776	10	
117806	64	

(28)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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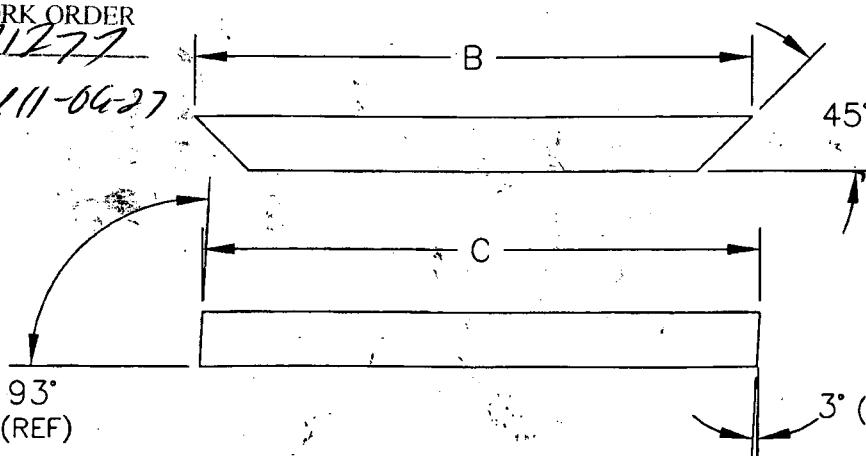
**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3324	REV. B	SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS	
A	04.10.20	NEW ISSUE		
B	05.03.04	UPDATE MESH MATERIAL SPEC		

## PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

SHOP COPY

RETURN TO  
ENGINEERING**RELEASED**  
05.03.05UNCONTROLLED COPY  
SUBJECT TO AMENDMENTWITHOUT NOTICE  
WORK ORDERNO. *71277**PL 11-06-27***DEO ATTACHED**

45° (TYP. BOTH ENDS)

OKAY  
05.03.05ASS 08.12.15  
**UNDER REVIEW**05.03.05 PH  
MISALIGNED  
DIMENSION PG2D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

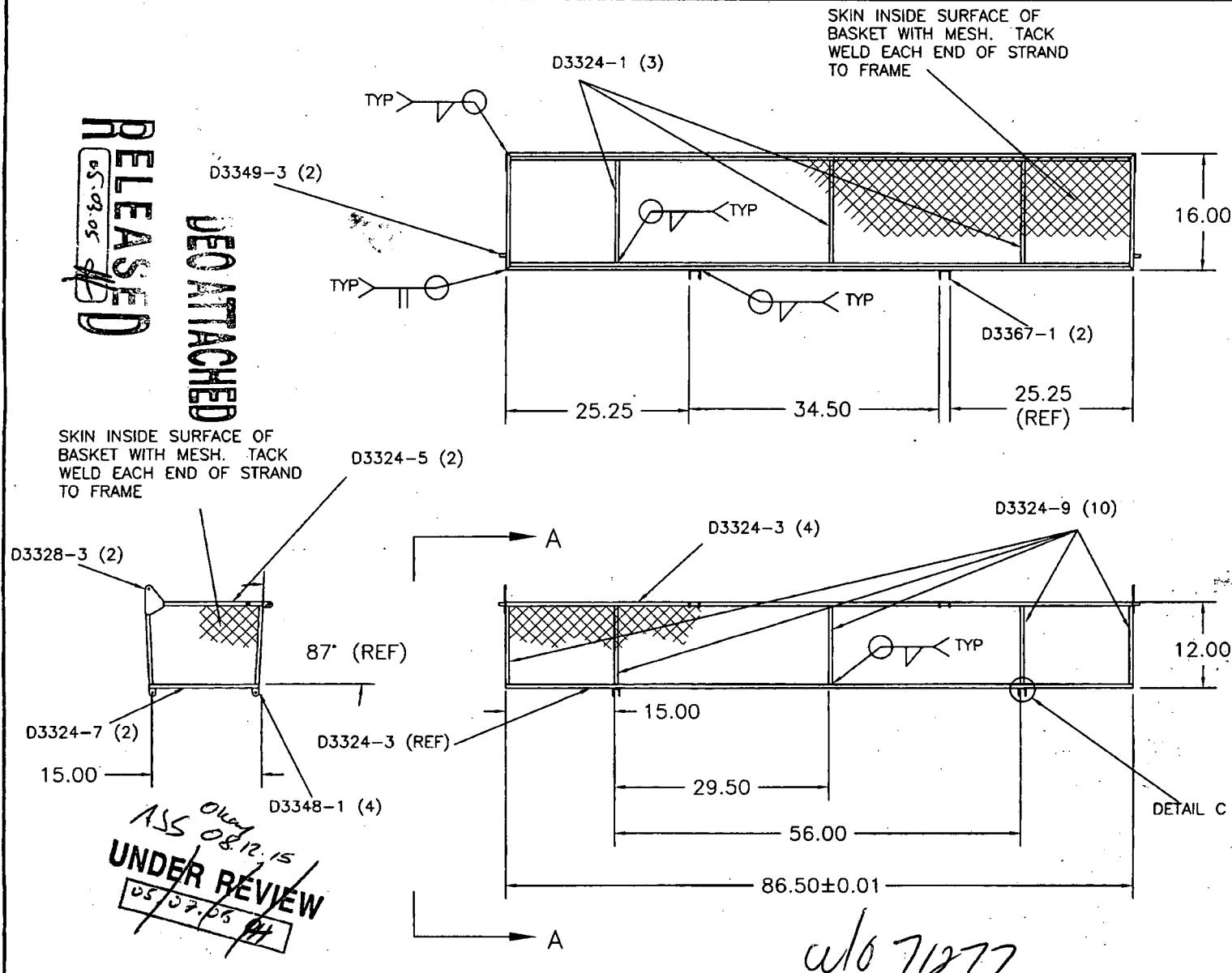
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.03.04	DRAWING NO. D3324	REV. B
TITLE BASKET BASE ASSEMBLY	SHEET 2 OF 3	SCALE 1:20



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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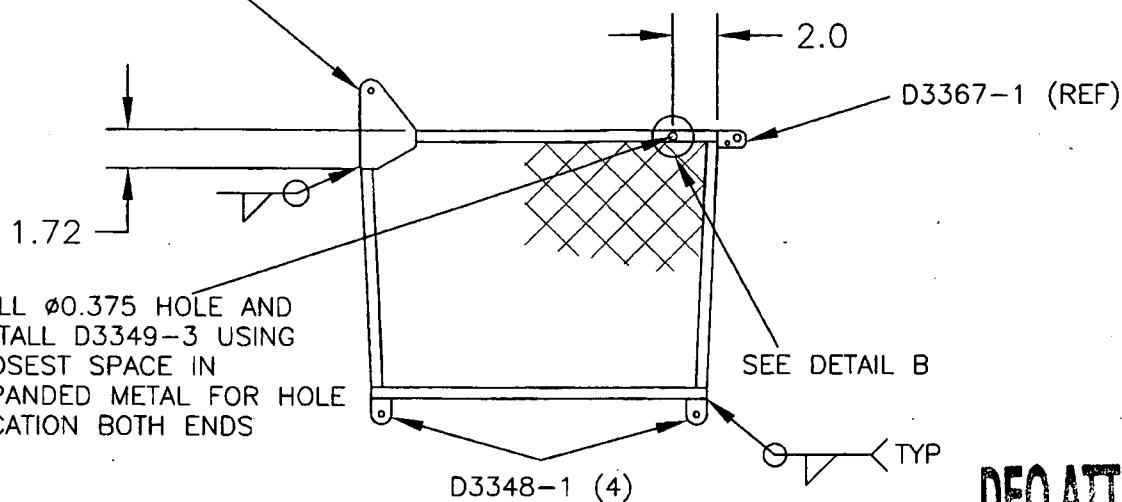
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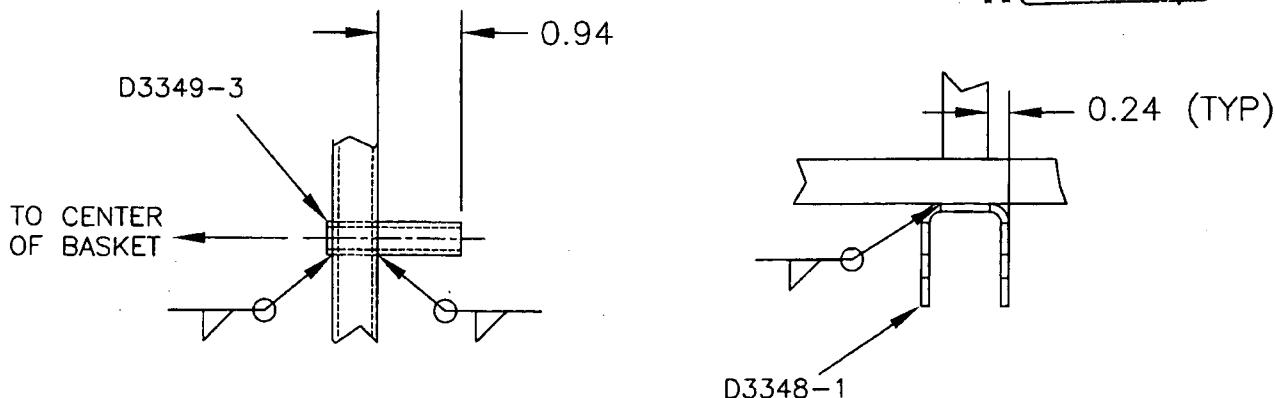
**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8

D3328-3  
HINGE PLATE  
(TYP BOTH ENDS)



RELEASER  
05.03.05



DETAIL B  
(SCALE 1:2)

*OKay*  
ASS 08.12.15  
UNDER REVIEW  
05.07.05 BY

DETAIL C  
(SCALE 1:2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

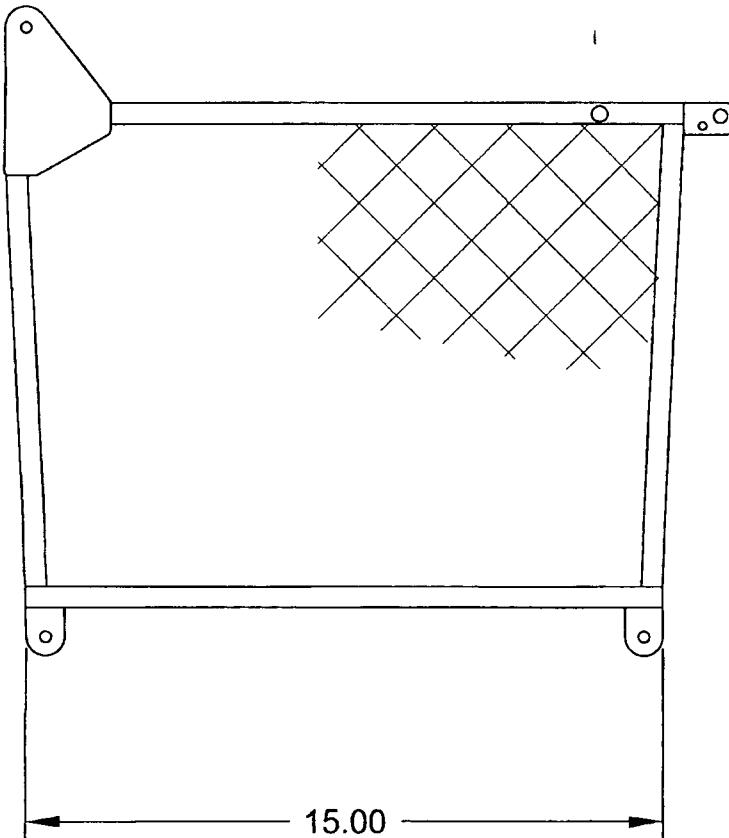
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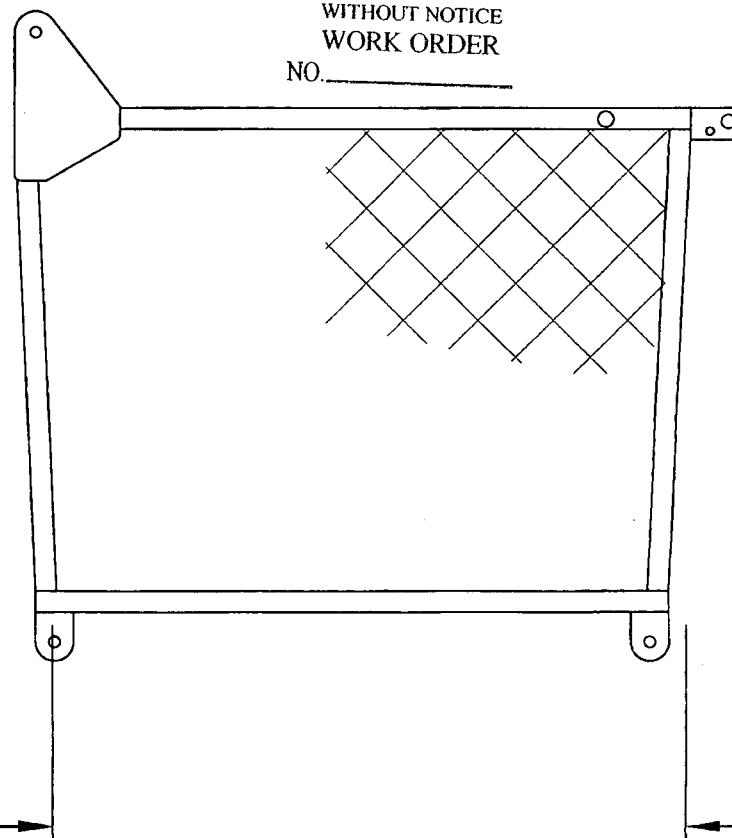
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>M</i>	MFG. APPR. <i>MP</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01	DATE 08.12.01		

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. \_\_\_\_\_

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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